

Work Order ID 130848

March-26-15 1:24:17 PM

130848

Page 1

Item ID: D2857-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 3/26/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MJ Date: 15-03-27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2857	Rev C								

100 0.00
100 BAND SAW 12 ~~0~~ DAS 44 15-03-30
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blanks 4.425"

110 0.00
110 HAAS CNC VERTICAL MACHINING #1 12 ~~0~~ DAS 20 15-04-01
 HAAS 1 Memo 0.05
 HAAS CNC vertical machine #1 1-Machine per folio FA940
 FOLIO REV: A4
 DWG REV: C
 2-Deburr any rough edges

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB 12 ~~0~~ DAS 20 15-04-01
 QC Memo 0.00
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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WORK ORDER NON-CONFORMANCE / UPDATE

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130848

March-26-15 1:24:18 PM

130848

Page 3

Item ID: D2857-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 3/26/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>M 131545</i> Memo START TIME: <i>1:00</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>1:30</i>	0.00 0.00				<i>12</i>	<i>0</i>	<i>15-4-21</i>	<i>38</i> <i>38</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>12x</i>	DAS 28 27	APR 2 2015	DAS 38 9-89
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>51015A</i> Memo	0.00 0.00				<i>12</i>	DAS 27 28		

APR 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
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Handling/Pre									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Work Order ID 130848***130848***

Page 4

Item ID: D2857-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Hinge Bracket

Stop

NS2

Start Date: 3/26/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/26/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00

190

QC

Memo

0.02

Quality Control

MCJ 15-04-23

(H) 15.4-22

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Picklist Print

March-26-15 1:24:15 PM

Page 1

Work Order ID: 130848

130848

Parent Item: D2857-2

D2857-2

Parent Item Name: Hinge Bracket

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP C 00.06.22 Removed P/O for powder coatEC
IPP D 06.03.30Added level 8 EC IPP Rev:E 11.01.06 as
per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	29.8560	0.37	5			

M6061T6B2 000X01 250

6061-T6 Bar 2.00 x 1.25

**

DAS
44
9-89

15/03/30

Location

MAT003

Loc Qty

29.856

Loc Code

M128247

20

*M128436

3

M129375

6.856

3
2.7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Material									
Operator									
Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Folio/Program
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear
☐ Crushing	☐ Countersink	☐ Misaligned/off center
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set
☐ Turning Sequence	☐ Finish	☐ Out of Calibration
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence
		☐ Outside Dimensions
		☐ Over/Under tolerance
		☐ Part Incorrect
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		☐ Pressure/Forced
		☐ Set-up
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

130848

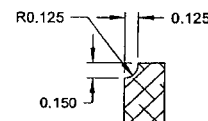
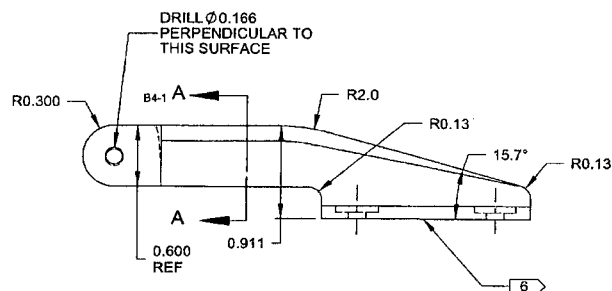
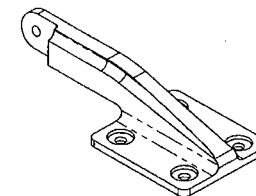
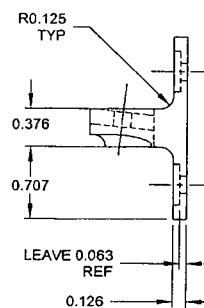
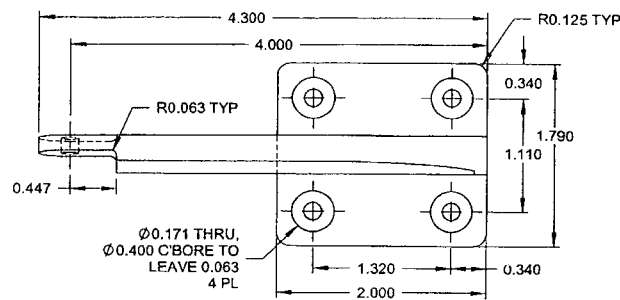
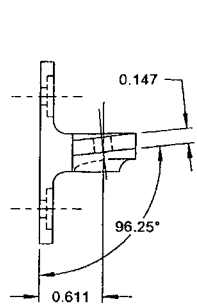
DART AEROSPACE LTD		Work Order: <i>130848</i>
Description: Hinge Bracket		Part Number: D2857-2
Inspection Dwg: D2857	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.3015	✓		Height	gauge
4.000	+/-0.010	4.0005	✓		"	
0.340	+/-0.010	.340	✓		SLO8	Vern
1.110	+/-0.005	1.110	✓		"	
1.790	+/-0.010	1.795	✓		"	
1.320	+/-0.005	1.320	✓		"	
2.000	+/-0.010	2.000	✓		"	
0.340	+/-0.010	.336	✓		"	
0.447	+/-0.010	.4465	✓		Height	gauge
Ø0.171	+0.005/-0.000	.175	✓		Gauge Pin	
0.147	+/-0.010	.142	✓		SLO8	
0.376	+/-0.010	.376	✓		"	
0.126	+/-0.010	.121	✓		"	
0.063	+/-0.010	.058	✓		"	
Ø0.166	+0.005/-0.000	.166	✓		Gauge Pin	
0.911	+/-0.010	.911	✓		Height	gauge
0.600	+/-0.010	.599	✓		SLO8	
0.125	+/-0.010	.124	✓		Height	gauge
0.150	+/-0.010	.148	✓		"	

Measured by: <i>DAS 20 9-89</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 15-03-31	Date: 15/04/04	Date:

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	
C	12.10.15	Dimensions update per Dwg Rev C	KJ	<i>[Signature]</i>



SECTION A-A

D2857-1 HINGE BRACKET

STAMP COPY

RETURN TO

ORIGINAL COPY

FOR USE TO A ENDMENT

WORK ORDER

130-848 MWS

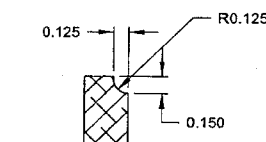
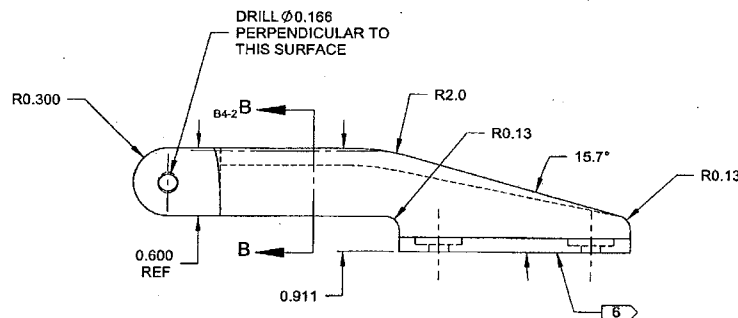
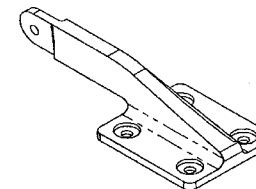
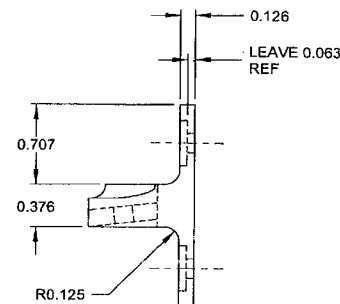
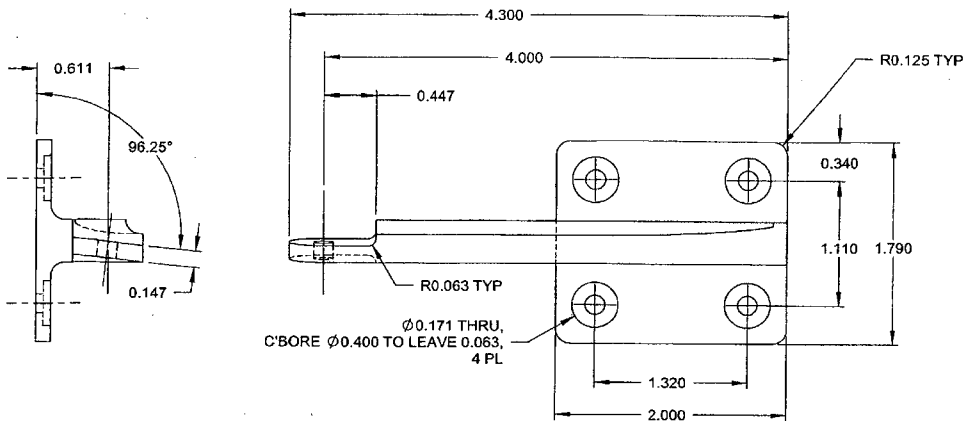
1503-23

RELEASED
2010-11-26

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG. IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	06.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2857 SHEET 1 OF 2 TITLE HINGE BRACKET SCALE NTS COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	10.09.13		



B7-2 SECTION B-B

D2857-2 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-2" PER DART QSI 044 6.1(FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2857	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE BRACKET	NTS
DATE	10.09.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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2010-11-26